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Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

D3913-041
Job Sheet 171850



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/8/18

Job Tracking No:

Due Date: 2/16/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/15/18	0.00	0.00	Start Up Large Fab-5		DML 18-2-22
100	Large Fab	1 pcs		2/15/18	0.00	10.00	Large Fab 1		14 18-2-26
110	QC	1 pcs		2/15/18	0.00	0.00	QC9		2PC
120	QC	1 pcs		2/15/18	0.00	0.00	QC5		1PC
125	HandFinish	1 pcs		2/15/18	0.00	0.29	HandFinish2		14 18-2-28
130	Powdercoat	1 pcs		2/15/18	0.00	0.93	Powdercoat2		BR 18-2-28
135	Packaging	1 pcs		2/15/18	0.00	0.00	Packaging1		14 18-3-01
140	QC	1 pcs		2/15/18	0.00	0.00	QC3		14 18-3-01
150	HandFinish	1 pcs		2/16/18	0.00	0.50	HandFinish4		14 18-3-01
160	QC	1 pcs		2/16/18	0.00	0.00	QC5		14 18-3-1
170	Packaging	1 pcs		2/16/18	0.00	0.00	Packaging3-2		14 18-3-01
180	QC21-SA	1 Ea		2/16/18	0.00	0.00	QC21		14 18-3-1

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M138467 START: 10:30 O.V.T. 375° FINISH: 10:45

DAS
21
9-89
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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5016037
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5041355
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5034377
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5041495
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	5038519
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5042220
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	5041029
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5042041
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	5036080
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5037501
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	5038112
D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	5041136
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5038117
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5042459
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5042462
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation	5036909
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	5041893
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	5041477
D2931	Bumper	2 Ea (2 ea)	150-HandFinish	5064351
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	5042091
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	5037284
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish	5020603
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish	5045376

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	68	0
	D3913-1	1	6	0
	D3913-15	1	21	0
	D3913-3	1	9	0
	D3913-7	2	15	0
	D3913-9	1	8	0
	D3916-041	2	10	0
	D3916-5	3	26	0
	D4016-1	3	83	0
	D4017-7	3	69	0
	D4017-9	2	14	0
	D4020-11	2	0	0
	D4021-1	3	60	0
	D4034-041	1	5	0
	D4034-043	1	5	0
	D4672-1	2	52	0
	M304EX0.75-16F	33	459	0
150-HandFinish	AN3-10A	6	60	0
	D2931	2	1,144	0
	D4021-5	2	11	0
	MS20600-AD4W3	2	159	0
	MS21042L3	6	3,757	0
	NAS1149F0332P	12	3,827	0

Part Specifications

Specifications could not be found.

001286

Plex 2/8/18 3:04 PM Dart.Gagnon.Michelle



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Container No: S044909



Part: D3913-041

Job No: 171850

Serial No/Batch: S044909

Revision: D4020, D3913

Inspector:

Date: 02/23/18

Master Unit 001139



Job No 171850